

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029566**Date Inspected:** 08-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL**CWI Name:** None present**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Elevator Cab frame assembly**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the Fabricator's shop and observed the work and the inspection performed by USA Hoist personnel. The inspection was performed on the Elevator Cab frame assembly and on the Elevator Tower Poles. The welding was performed utilizing Flux-Cored Arc Welding with shielding gas process (FCAW-G) as per the approved Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

No Quality Control (QC) inspector was present this day.

The welding of the Tower Elevator guiderail poles continued this day. The welding was performed by Jose Dominguez #C utilizing E71T-1 FCAW-G electrodes as per AWS A5.20 and allowed per AWS D1.1. The WPS's being used were FCAW3210 and FCAW3139. The welding being performed was of rack spacers, gusset stiffeners, mounting plates, and end connection brackets to the guiderail poles.

Drainage hole drilling of the Elevator Cab frame was observed by this QAI today as a preparation to aid in the galvanizing process scheduled. The drilling location recommendations were provided by a representative of AZZ Galvanizing. The drilling of the specified locations of the Elevator Cab frame drainage holes was not fully completed this day.

WELDING INSPECTION REPORT

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Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer